

# Work Order ID 76676

*Ship TODAY*  
**\*76676\***

Page 1

November-21-11 7:25:57 AM

Item ID: D3234-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: ~~11/R~~

Stop **\*NS2\***

Item Name: Doubler

Start Date: 11/21/11 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 11/21/11 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3234

*11.21*

*ECN 11-674*

100

**\*100\***

Waterjet

FLOW WATER JET

Memo

0.00

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3234

Dwg Rev: *11.21*

Prog Rev: *11.21*

Deburr if necessary

*+ ATTACHED EMAIL FROM D. SHEPHERD DATED 11.11.18.*

*11-11-21*

*2004 .086*

110

**\*110\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*11-11-21*

120

**\*120\***

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*5/11/21*

*10 Rev C*

*(11)*

*(11)*

# Work Order ID 76676

**\*76676\***

Page 2

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Required Date: 11/21/11 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>179</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									

6x0 m-11/11/21

6x d m-11/11/21  
counted

11/11/21 (6)

**Work Order ID 76676****\*76676\***

Page 3

November-21-11 7:25:57 AM

Item ID: D3234-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID: U/R

Item Name: Doubler

Stop **\*NS2\***

Start Date: 11/21/11 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 11/21/11 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

w/n/21 *[Signature]**MF*  
11-11-21

# Picklist Print

November-21-11 7:25:57 AM

Page 1

Work Order ID: 76676  
Parent Item: D3234-1  
Parent Item Name: Doubler

Start Date: 11/21/11 Required Date: 11/21/11  
Start Qty: 5.00 Required Qty: 5.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC  
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S:050 2024-T3 .050 sheet		Purchased	No			100	sf	73.6000	0.579	3.0473684		3.5	

Location

Loc Qty

Loc Code

MAT022

73.6

117684

73.6

117684

(6)

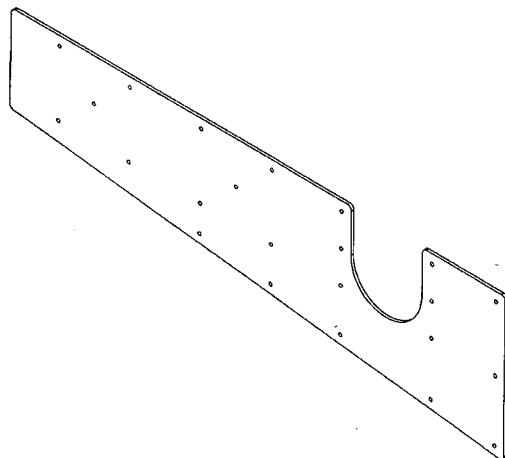
DART AEROSPACE LTD	Work Order: 76676
Description: <u>Doublet</u>	Part Number: <u>D3234-</u>
Inspection Dwg: <u>D3234-1</u> Rev: <u>Rev C</u>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

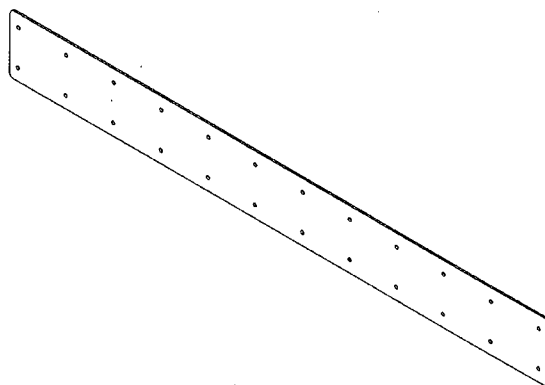
☒ First Article     ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .092	+ .004 - .001	.102			V <u>11362</u>	
.285	± .010	.286	2		V	
1.295	± .010	1.297	2		V	
2.305	± .010	2.307	2		V	
2.700	± .010	2.707	2		V	
1.523	± .010	1.523			V	
2.641	± .010	2.640	1		V	
3.758	± .010	3.760	2		V	
5.993	± .010	5.995	2		V	
7.111	± .010	7.113	2		V	
8.228	± .010	8.227	2		V	
10.463	± .010	10.467	2		V	
10.77	± .030	10.771	2		V	
2.228	± .030	2.247	2		V	
13.333	± .010	13.333	1		T <u>Bol</u>	
15.366	± .010	15.366	2		T	
15.665	± .010	15.665	2		T	
1.33	± .030	1.33	2		V	
4.505	± .010	4.500	2		V	
.266	± .010	.260	2		V	
1.080	± .010	1.080	2		V	

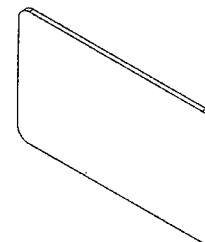
Measured by: <u>IB</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>11-11-21</u>	Date: <u>11/11/21</u>	Date:
<u>Rev C</u>		
Rev A	Date -	Change
		New Issue
Revised by		Approved
KJ/JLM		



**D3234-1 DOUBLER**



**D3234-3 DOUBLER**



**D3234-5 SPACER**

**NOTES:**

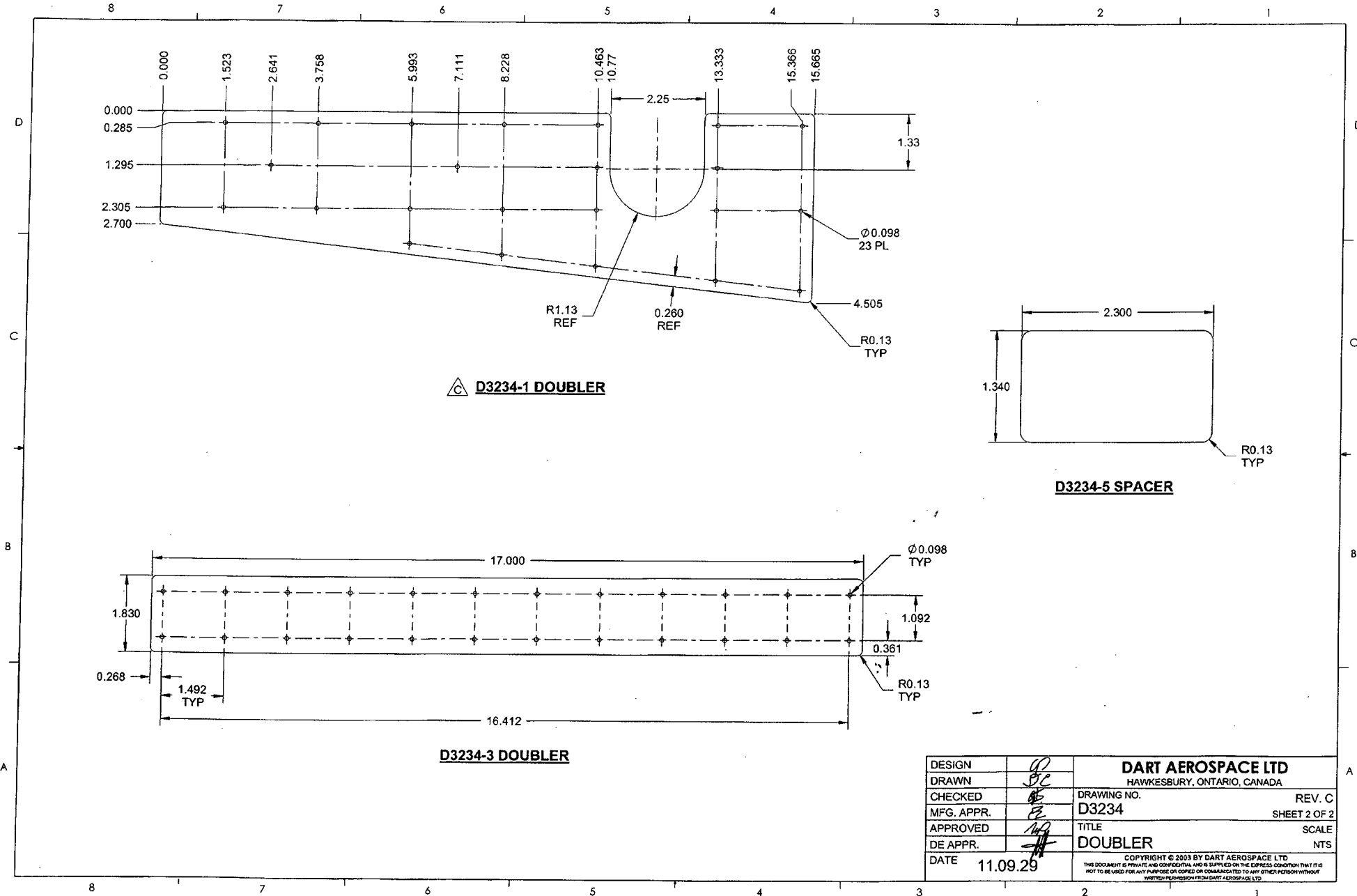
1) MATERIAL: -1: 2024-T3 ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.080

-3: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1  
7) WEIGHT: -1: 0.41 lbs  
-3: 0.15 lbs  
-5: 0.01 lbs

C	RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347, ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-118.	JLC	11.09.29
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	JLC		
CHECKED	JE		
MFG. APPR.	JE		
APPROVED	MA		
DE APPR.	MA		
DATE	11.09.29		
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## Linda Lacelle

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** November-18-11 4:44 PM  
**To:** 'Linda Lacelle'  
**Cc:** Daniel Campbell; Harvey Siemens; Mike Petsche; 'Marc Bellavance'  
**Subject:** D3234 Rev C  
**Attachments:** D3234RevC.pdf

Linda,

I have finally signed this dwg ... See attached.

FYI, the part needs to be made from 0.080" 2024-T3 and has a few extra rivet holes.

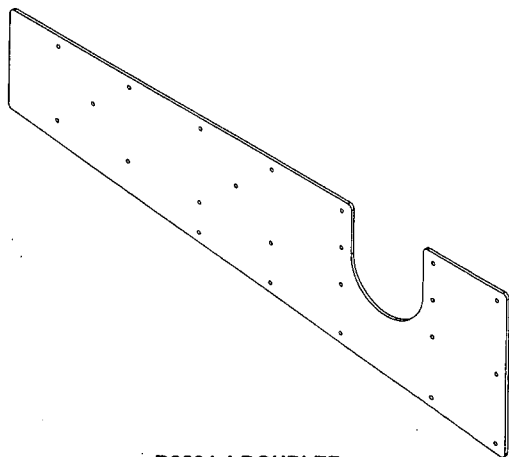
Dan has loaded the new DXF file into Preliminary.

Sorry for the delay and confusion.

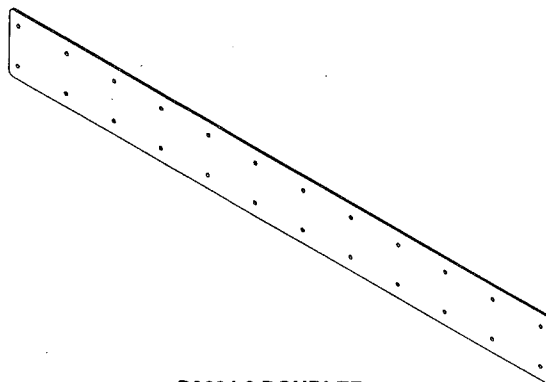
Have a good weekend.

David

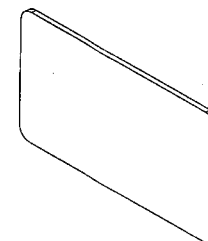




**D3234-1 DOUBLER**



**D3234-3 DOUBLER**



**D3234-5 SPACER**

**NOTES:**

1) MATERIAL: -1: 2024-T3 ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.080

-3: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1  
7) WEIGHT: -1: 0.41 lbs  
-3: 0.15 lbs  
-5: 0.01 lbs

**RELEASED**  
2011-11-33

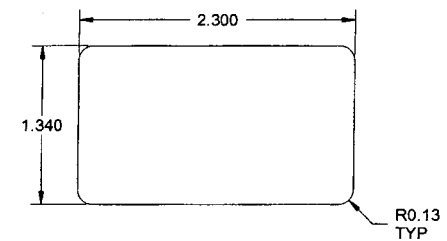
C	RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347, ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-118.	SC	11.09.29
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.09.29		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3234** REV. C  
SHEET 1 OF 2  
TITLE **DOUBLER** SCALE NTS

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**D3234-1 DOUBLER**



**D3234-5 SPACER**

**D3234-3 DOUBLER**

RELEASED  
2011-11-23

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	BE	D3234	SHEET 2 OF 2
APPROVED	BE	TITLE	SCALE
DE APPR.	BE	DOUBLER	NTS
DATE	11.09.29	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	